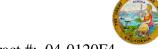
### DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

## WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-010095 Address: 333 Burma Road **Date Inspected:** 30-Sep-2009

City: Oakland, CA 94607

**OSM Arrival Time:** 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name:** Lv Li Qing / Shen Fu You **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A **Qualified Welders:** Yes No N/A **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:** 

**Bridge No:** 34-0006 **Component:** OBG Assembly

### **Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Tim McClendon was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

**OBG** Assembly Bay 14

Flux Cored Arc Welding (FCAW) on Lifting Lugs to Floor Beam of weld joint SEG 054 SSD20 PP79 for OBG assembly weld numbers 235 and 255 for Segment 9CE. The ZPMC welders identified as 044774 was welding in the 3G position. The ZPMC QC identified as Wang Xu was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2233-Tc-U5-F.

Flux Cored Arc Welding (FCAW) on Lifting Lugs to Floor Beam of weld joint SEG 054 SSD20A PP79 for OBG assembly weld numbers 234 and 254 for Segment 9CE. The ZPMC welders identified as 044795 was welding in the 3G position. The ZPMC QC identified as Wang Xu was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2233-Tc-U5-F.

Shielded Metal Arc Welding (SMAW) on side panel splice of weld joint SEG056A OBG assembly weld number 032 for Segment 9DE. The ZPMC welder identified as 044779 was welding in the 4G position. The ZPMC QC identified as Wang Xu was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

# WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Shielded Metal Arc Welding (SMAW) on Dick Panel to Edge Panel of weld joint SEG056\* OBG assembly weld number 046 for Segment 9DE. The ZPMC welder identified as 067764 was welding in the 4G position. The ZPMC QC identified as Wang Xu was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2214-Tc-U4B-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### **Summary of Conversations:**

No relevant conversations spoken on this date.

#### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

<b>Inspected By:</b>	McClendon, Timothy	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer